

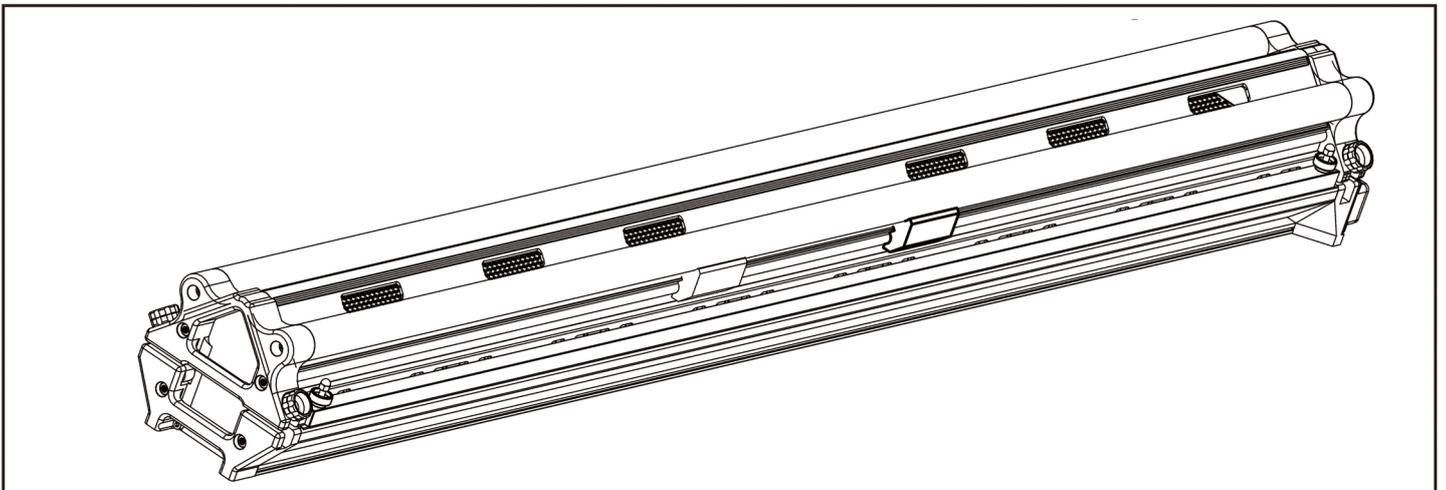
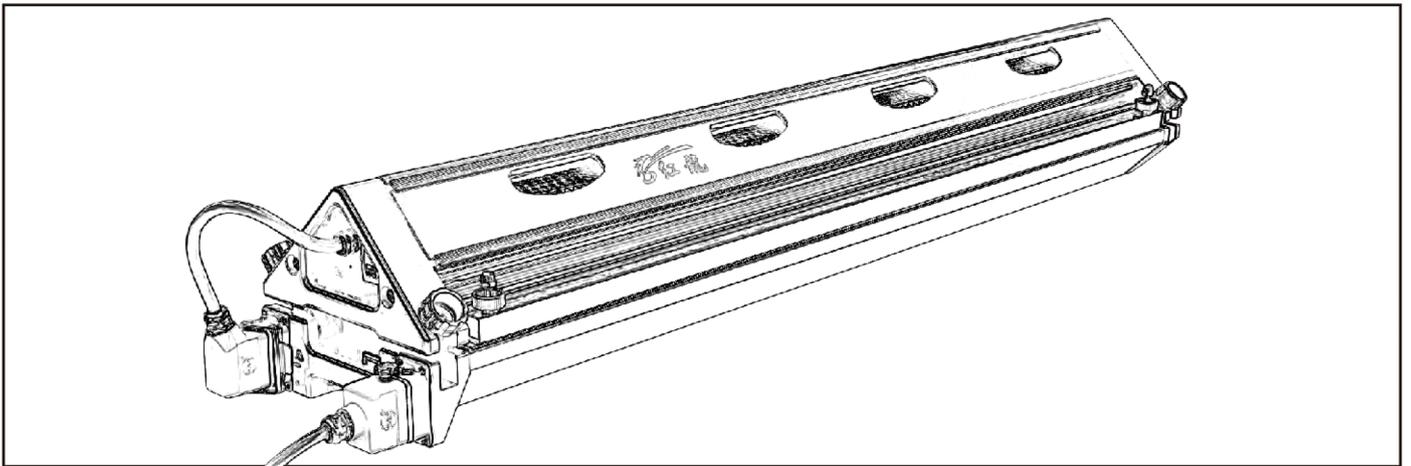
# HOLO<sup>®</sup> Splice press

## Safety and Operation Manual

Quick Joint All-in-one Machine Vulcanizing Press

PA300 – PA600 – PA900 – PA1200 – PA1500

PA1200H – PA1500H – PA1800H – PA2100H



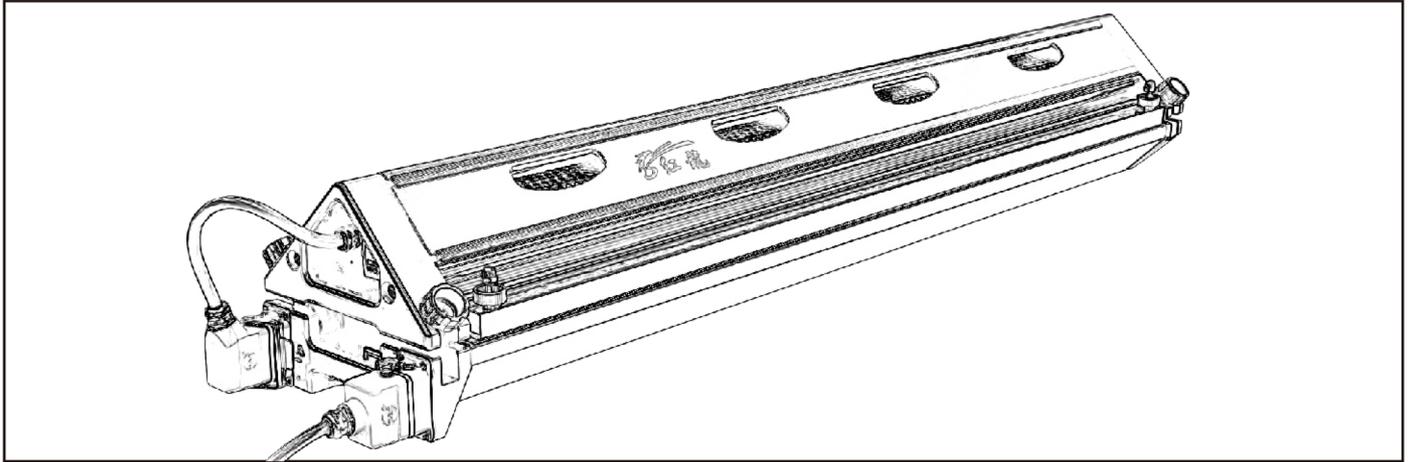
### WARNING

IMPROPER OR UNSAFE use of this tool can result in serious bodily injury! This manual contains important information about product function and safety. Please read and manual available for other users and owners before they use the tool. To understand this manual BEFORE operating the tool. Please keep this is manual should be stored in a safe place.

## Quick Joint All-in-one Machine Vulcanizing Press

Be sure to read and completely understand this procedure before applying product.

Be sure to select the proper PREFORMED product before application.



### CONSIDERATIONS:

This Application Procedure is valid for PLP Compression Splice (CMPSP) Assemblies on ACSR Conductors only.

### TOOLS SPECIFICATIONS:

1. 300mm effective(12")
2. 600mm effective(24")
3. 900mm effective(36")
4. 1200mm effective(48")
5. 1500mm effective(60")
6. 1800mm effective(72")
7. 2100mm effective(84")

### MAIN COMPONENTS

- Clamp Bar Studs & Thumbnuts
- Top Press Beam
- Handle
- Press Connector Bolts
- Clamp Bar
- Bottom Press Beam
- Start Button (green)
- Eurotherm Heat and Time Controller
- Umbilical Power Cable Connector
- Pressure Controller
- Pressure Relief Button (red)
- Main Power Cable Connector

### FEATURES AND BENEFITS:

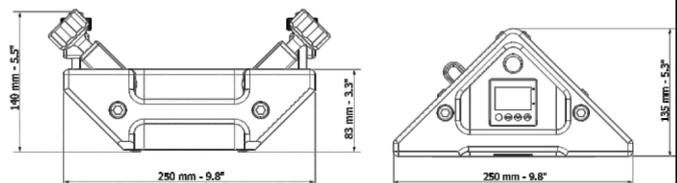
The PA series air cooled press, have different models for width from 300 mm to 2100 mm

- 1.Used for pvc belt etc. thermoplastic belt materials portable splice press, light weight and with flight case as standard packing, is easily removed to any where for job site use
- 2.Fast splicing: include heating time and cooling time, only 9-12 mins.
- 3.All In one design: the press has an integrated air-cooling system and also air compressor inside, to ensures that the belt is quickly cooled down and auto press on, without water pump or additional air compressor.
- 4.Light weight

5.Easy to use and assemble, how to operate pls freely to refer to below video.

6.Reliable and automatic temperature control with time control (in one meter, also you can set by yourself), air pressure controller (set the air pressure and display the current pressure)

7.Voltage: 220v or 380v, if special voltage pls freely to inform us.

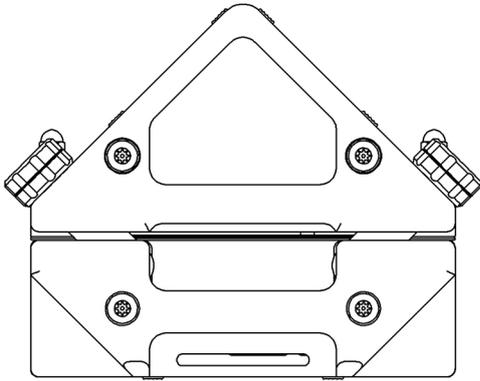


# HOLO® BELTS PRESS MACHINE

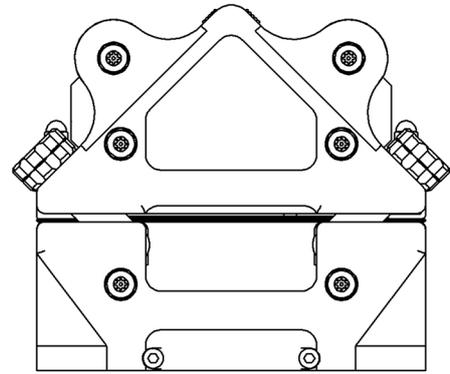
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## DATASHEET AIR COOLED PRESS

Model	PA 300	PA 600	PA 900	PA 1200	PA 1500	PA 1500H	PA 1800H	PA 2100H
Effective length	305mm / 12"	610mm / 24"	914mm / 36"	1219 mm / 48"	1524 mm / 60"	1524 mm	1829 mm	2200 mm
Effective width	130mm / 5.1"	130mm / 5.1"	130mm / 5.1"	130mm / 5.1"	130mm / 5.1"	130mm	130mm	130mm
Weight upper part	10 kg	16 kg	20 kg	28.5 kg	30 kg	45KG	63.3kg	72 kg
Weight lower part	11 kg	13 kg	18 kg	25.5 kg	30 kg	53kg	47.5 kg	67kg
Total weight	21 kg	30 kg	38 kg	54 kg	62 kg	100 kg	121 kg	142kg
Overall Height	220 mm	225 mm	225 mm	225 mm	225 mm	255 mm	255 mm	255 mm
width						250mm	250mm	250mm
Length	505 mm	805 mm	1105 mm	1405 mm	1705 mm	1700 mm	2005 mm	2300 mm
Max. pressure	1.5 Bar / 22 PSI	1.5 Bar / 22 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	2 Bar / 28 PSI	1 Bar / 14.5 PSI	1 Bar / 14.5 PSI
Max. temperature	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F	200 °C / 390 °F
Power(仅作参考)	1.2 kW	3.2 kW	4.5 kW	5.8 kW	7 kW			
press+case weight	39KG	52kg	66kg	80kg	95kg	132KG	158kg	188kg
press+case+wooden box weight	50kg	72kg	89kg	104kg	115kg	153KG	190KG	225KG
wooden box size (L*W*H)	790*430*420	1090*430*420	1390*430*420	1720*450*430	1990*430*420	1990*430*520	2130*450*520	2500*450*520

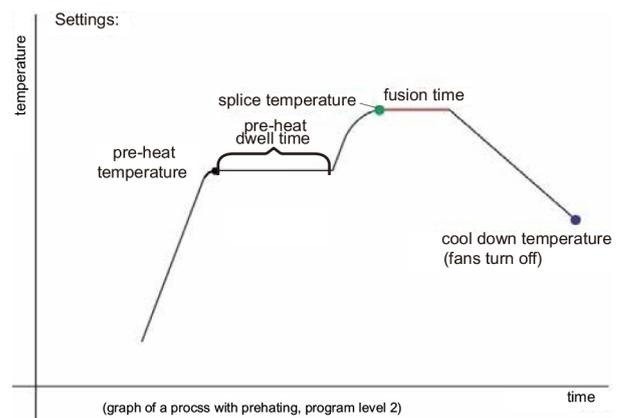
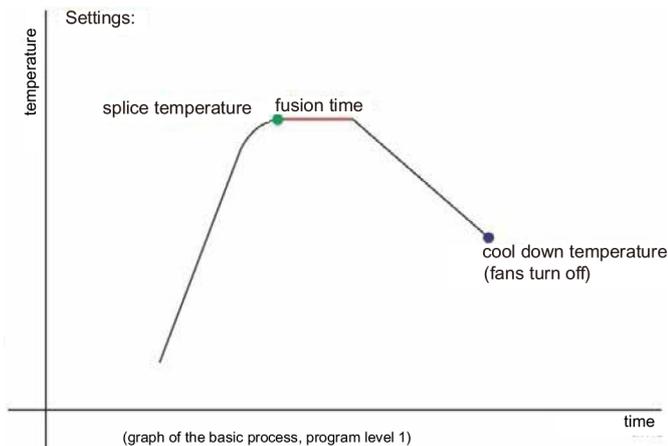


PA300-PA600-PA900  
PA1200-PA1500



PA1200H-PA1500H  
PA1800H-PA2100H

Inside to reach the required temperature. Melted material might flow away or discolor and fabrics might shrink. To avoid this problem, the preheat option can be used. This option heats the belt up (outside and inside) to a temperature just below the melting temperature. After the preheat stage, the inside splice temperature can be reached much quicker, minimizing the risk for unwanted flow of material, discoloring or fabric shrinkage.



\*\* The reading of the display relates to the top temperature of the press. If more or less heat is required at the bottom of the belt, the "bottom heat factor" can be used. Please note that this factor relates to a plus or minus amount of heat (%), not to a specific temperature.

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# HOLO® BELTS PRESS MACHINE

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## Flight Case

1. HOLO® PA press are supplied with a flight case for both storage purposes and also for easy transport to on-site jobs.
2. Place press in the flight case so the end with the power receptacles is facing the storage compartment. This will protect the receptacles from damage when transporting.
3. Flight case for the PA 300-900 have two wheels. PA 1200-2100 are packaged in flight cases with four wheels and an extension handle.
4. Flight cases can be stacked on top of each other, but need to be secured during transportation.
5. PA 1200-2100 flight cases feature an extended handle for ease and convenience in transport. Click in the grip of the flight case to release the handle.



## General Safety Rules

[Save These Instructions](#)

### Signal words:

“DANGER” indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury. The signal word is limited to the most extreme situations.

“WARNING” indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

“CAUTION” indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.

### Safety Symbol



This international safety symbol is used to identify and call attention to specific safety matters.

### Safety Information

To Avoid Severe Personal Injury or Property Damage, read carefully and understand the following Safety Precautions.

### Overall Safety rules

#### ⚠ DANGER

To Avoid Severe Personal Injury or Property Damage, read carefully and understand the following Safety Precautions.

#### ⚠ DANGER

Terminate electrical hazards by removing power cord from wall receptacle or machine base inlet.

#### ⚠ WARNING

Terminate pressure related hazards by pressing the red pressure relief button.

#### ⚠ CAUTION

Press platens develop over 5 tons of clamping force. When operating the press keep the four press connector bolts in place by hand tightening.

#### ⚠ CAUTION

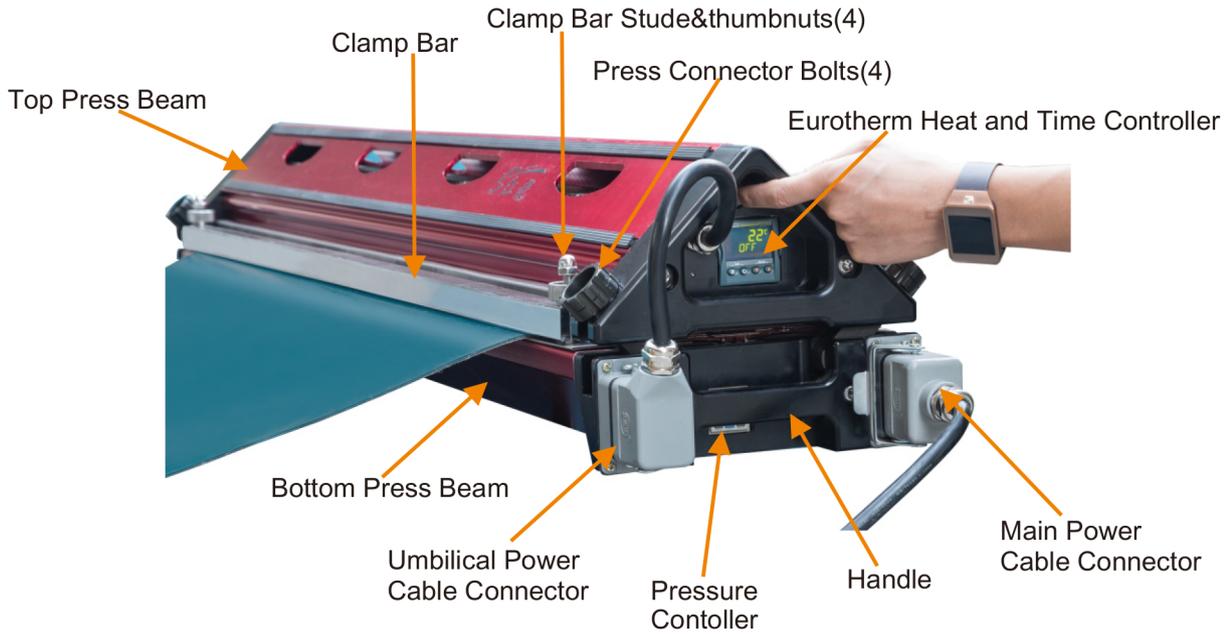
Avoid temperature related hazards by handling press components and belt once safely cooled.

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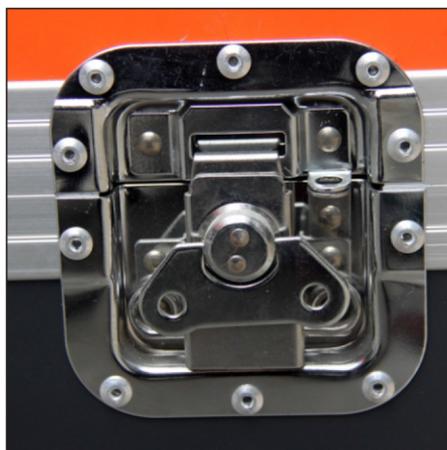
## MATTERS OF PARTICULAR

This manual will be referred to the key components of the following, if failed to account for the location, please refer to the map to understand.



## UNLOCK AND OPEN

Open the box and carried out the simple steps of the machine, the machine weight of different length is different, need two or more people to pay attention to the bottom of the box out, locking universal wheel when in operation



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## 1 Remove top beam:



- a. Loosen all four press connector bolts.
- b. Using top beam handles located on end caps, remove top beam from press.

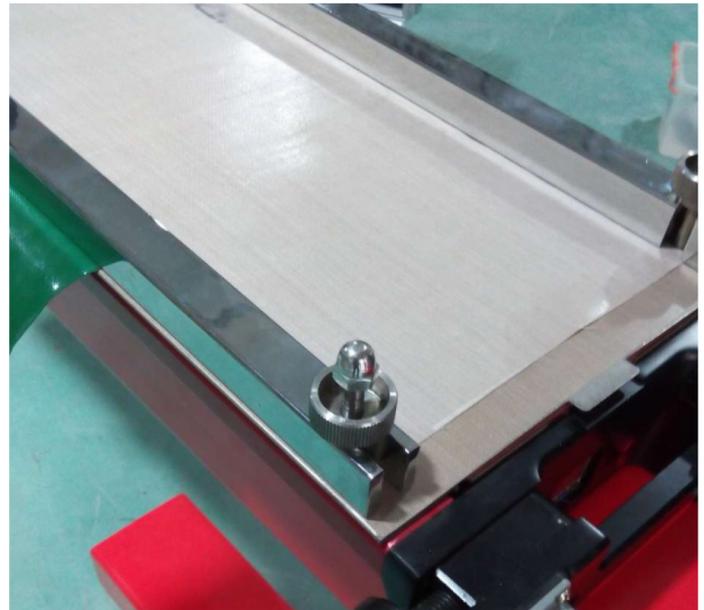


Depending upon width and weight of the press, you may require assistance from another person.

- c. Place beam on side, do not place the beam with the platen facing down. It is important to keep platens in good working condition. Resting the beam on the side will protect the platens from scratching or from getting dirty. Beams have rubber stripping along the length of the press to protect from scratching (see photo).

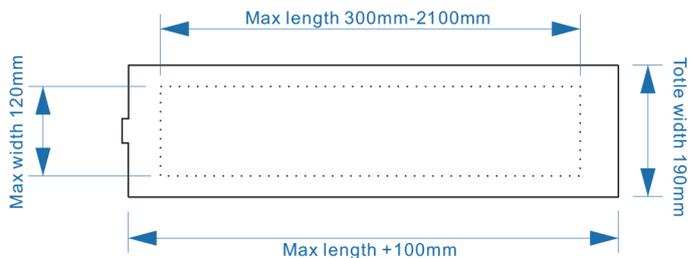
## 2 Remove Handle:

Rotating metal nut, a metal rod out of its grip. The metal rod on this device is used to fix the position of the belt to the joint, the corresponding after removing the belt into the need to re add metal bar and tighten the nut



## 3 Insert prepared belt ends into the press:

- a. Lay clean silicone pad over clean bottom platen. Use care to lay silicone pad flat; wrinkles in silicone pad will impact the finished appearance of the splice. Silicone pads are used to prevent belt material from sticking to the platens of the press.
- b. Lay prepared belt ends on the bottom platen. Note: The heated zone is in the center 130 mm width of the platen; outside of this area the platens are in the integrated cool zones. Be sure splice area is centered properly. There is some 'heat loss' on the outside areas of the heated zone, which is dependent upon the belt type. Typically the 'melt zone' is approximately 120 mm. Prepared finger splice and/or ply separation must be within the 'melt zone', as material outside of the melt zone will not become molten.



- c. Ensure prepared belt ends are tight together. If installing a finger splice, make sure that the finger tips are fully meshed without gaps between top and bottom of the fingers. Heat tack in place if needed.
- d. If film/foil is needed for the splice; apply to prepared belt end.
- e. It is important to use 'bumpers'. Bumpers prevent the melted material from flowing outside of the belt width and also provide stability in the press.

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## ⚠️ CAUTION

The bumpers must be to a width that will fill the balance of the press to ensure even pressure and prevent damage to the press.

f. Install clamp bars, ensuring that fingers remain tightly meshed.

g. Lay clean silicone pad over the prepared splice, using care to avoid wrinkles in the silicone pad.

## ⚠️ CAUTION

h. The belt in place, we must pay attention to put down the two splints, and tighten the nut around a total of 4, to ensure that the belt is fixed on the machine.



## 4 Install top beam:



a. Carefully position top beam onto prepared belt ends; avoid disrupting prepared belt ends and possibly separating the fingers.

## ⚠️ HEAVY OBJECT

If weight and length of top beam is difficult to handle by yourself, enlist assistance of another person.

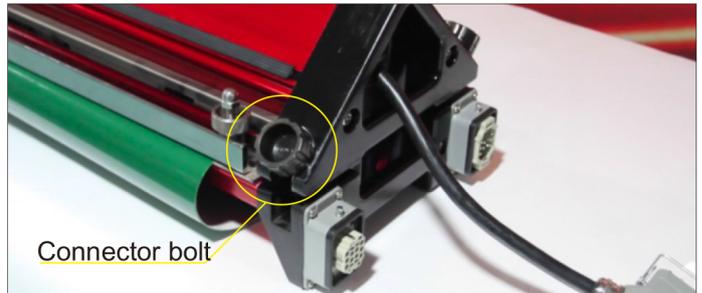
i. PA 900, 1200, and 1500 models include a fixture to aid in sliding top beam in place if access to position beam is difficult. Install fixture in slots of end caps. Slide top beam the length of the tool. Lift end to remove fixture.



## ⚠️ DANGER

b. Center top beam so that all four connector bolts are free to fully rotate upwards. This is necessary for proper press alignment. Hand tighten the bolts, ensuring they are seated properly in spherical recess on top beam.

## ⚠️ DANGER



i. Do not allow users to get fingers caught in potential pinch points.

## ⚠️ DANGER

ii. Press is capable of producing a force up to 10,250 pounds (45,600 N). Do NOT operate the press with a missing or broken bolt as this can cause serious physical harm and/or damage to press. If a bolt is missing or broken, replace with authorized factory parts only.

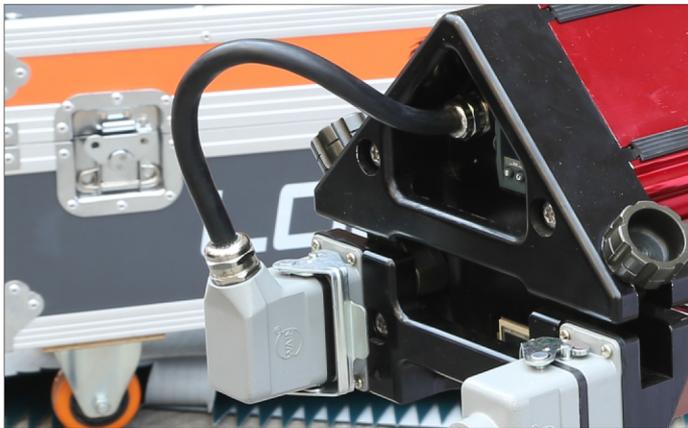
## ⚠️ WARNING

iii. To ensure proper thread engagement, the prepared belt ends (including various pads) cannot exceed 15 mm (0.59"). This does not necessarily relate to the press' heating capability. Exceeding this thickness will not allow sufficient thread engagement of the Connecting Bolts to ensure safe clamping of the press, and can result in damage to the press and personal danger.

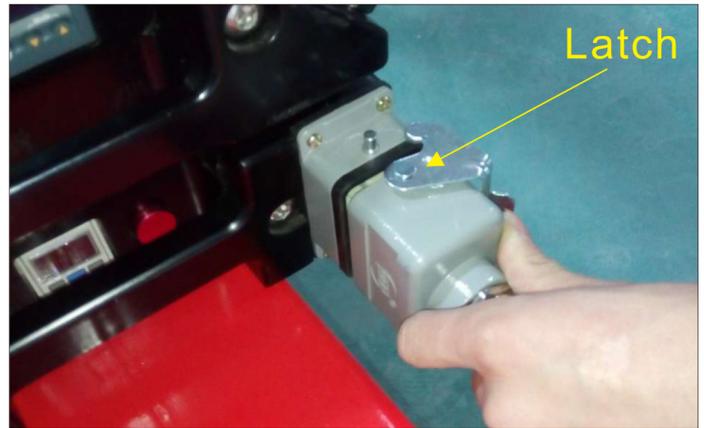
# HOLO<sup>®</sup> BELTS PRESS MACHINE

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## 5 Connect umbilical power cable from top beam to bottom beam:



b. Engage latch to lock plug in place. Forgetting to lock plug can result in intermittent power supply to the press.



**⚠ DANGER**

c. Double check to ensure the voltage and receptacle is appropriate for the power cable you are using. Incorrect, excessive power voltage can cause serious damage to press and also present physical danger (i.e. 460 volt outlet feeding into a 230 volt cable could cause a short circuit and/or fire).

## 6 Connect power cord to press:

a. Insert umbilical power cable connector into machine base umbilical cable connector.

b. Engage latch to lock plug in place. Forgetting to latch plug can result in intermittent power supply to press base controls.

**⚠ WARNING**

It is extremely important that the power cord is attached to the press first and then to the wall receptacle. Reversing these procedures can put personnel at risk of electrocution and may cause a damaging electrical arc.

a. Insert power cable connector to the machine base power outlet.



## 7 Connect power cord to press:

Connect the PA press to the power supply. The following parameters can be set:

a. Controller on top part of the Aero

i. Input level 1

- Splice temperature (max. 200°C/392°F)
- Splice temperature dwell time
- Cool down temperature

ii. Input level 2

- Preheat temperature
- Preheat dwell time
- Splice temperature
- Splice temperature dwell time
- Cool down temperature
- Bottom heat factor (lower or higher than top heating)

b. Controller on bottom part of the Aero

i. Splice pressure (0-max. 2 bar/28 psi)



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The Eurotherm controller defaults at start up to Level 1 programming. All settings are presented as an abbreviation, e.g.

“SPL.T”. If you wait a moment a readable text is shown, e.g. “Splice Temperature”.

## Level 1 Input:

a. Setting Basic Temperature and Dwell Time Inputs.

i. Setting of the splice temperature

- Push button  $\cup$ . The first value shown is splice temperature (SPLT).
- Change the actual setting by pushing the UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button.
- Wait for one second and the displayed value blinks to confirm that it is set.
- Maximum temperature is limited to 200°C (392°F).

ii. Setting splice temperature dwell time

- Push button  $\cup$  until display shows “SPLDT”.
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to adjust dwell time;
- Wait for one second and displayed value blinks to confirm that it is set.

iii. Setting cool down temperature (when cooling fans will turn off).

- Push button  $\cup$  until display shows “CLD.T”.
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to adjust cool down temperature.
- Wait for one second and displayed value blinks to confirm that it is set.
- Return to start up status by pushing button  $\cup$  again.

Splice Pressure (bottom controller)

b. Setting splice pressure

- Briefly push the middle button S (display shows set value).
- DON'T HOLD S BUTTON or otherwise the parameter menu will open.
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to adjust splice pressure.
- When desired value is shown set by briefly pushing middle button S again.
- Maximum pressure is limited to 2 bar (28 psi).

## Additional temperature and dwell time settings: Changing to Level 2 programming:

Setting of the splice temperature

- Push button and hold button  $\text{Ⓢ}$  until display shows “Lev1”.
- Push the UP  $\blacktriangle$  button once and display shows “Lev2”.
- Program level 2 settings are available now.

Setting preheat temperature (default value 100°C)

- Push button  $\cup$ . The first value which is shown on the display is the preheat temperature (PREHT).
- Change actual setting by pushing UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button.
- Wait for one second and displayed value blinks to confirm that it is set.

- Maximum preheat temperature is limited in controller to 175°C (347°F).

Setting preheat dwell time (default value 0 sec)

- Push button  $\cup$  until display shows “PREHD”.
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to adjust dwell time.
- Wait for one second and displayed value blinks to confirm that it is set.

Note: Splice temperature, splice dwell time, and cool down temperature will remain in effect from Level 1 programming..

Setting splice temperature, splice dwell time, and cool down temperature.

Setting of the bottom platen at a lower temperature (default value 0°)

- Push button  $\cup$  until display shows “BOTHF”.
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to adjust percentage of power that is desired for bottom platen (e.g.-10=sending 90% of the power supplied to the bottom platen.) You can adjust +5% to -99% power.
- Note: Actual bottom heat temperature cannot be input.
- Wait for one second and displayed value blinks to confirm that it is set.

Changing from degrees Centigrade to Fahrenheit and reverse

- Push button  $\cup$  until display shows “UNITS”
- Push UP  $\blacktriangle$  or DOWN  $\blacktriangledown$  button to change from °C to °F or reverse.
- Wait for one second and displayed value blinks to confirm that it is set.
- Return to start up status by pushing button  $\cup$  again.

**ATTENTION:** If the PA is disconnected from the power supply, or the top part is disconnected from the bottom part, all extra settings of level 2 return to their default value. Only the basic settings (as level 1) and the setting for units (°C/°F) will be kept.

## 8 Start Splicing Operation:

Before initiating splicing cycle, confirm all four press connector bolts are engaged with top of press and are hand-tight. Depress green ‘Start’ button. Air compressor will start and you will be able to view status of splicing cycle by watching digital display on control panel. Air pressure will continue to build after the compressor stops.



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**Note:** It is common for the air pressure to continue to rise beyond

input value. This is due to the effect of the heat generated by press causing additional expansion in air bladder.

Although press remains fairly cool during entire splice cycle, it is wise to avoid touching press during heating and cooling down process.

**Note:** The PA has been optimized for process speed, portability

and ease of use. A resulting affect of the designed portability of the press is that the structure will deflect as internal air pressure is increasing during the splicing process. The length of the press will determine how much deflection will occur at any specific pressure. Beam extrusions were designed with strength to return to their normal state when pressure is relieved; deflection will not be permanent.

## WARNING

Keep fingers clear of deflected beams.

## CAUTION

The PA press does not have an 'Emergency Stop' button. If there is a need to stop the press mid-cycle, then disconnect the press from power source and allow press to cool.

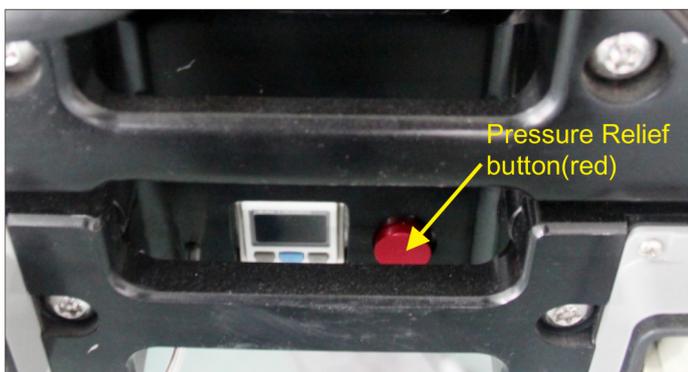
NOTE: Temperature cycle may be aborted by simultaneously pressing and holding the ▲ and ▼ buttons.

## 9 Connect power cord to press:

During the splicing cycle you will be able to monitor progress by viewing the display output. Fans will start up at the end of the cook cycle to assist with fast cooling of the splice. If the fans do not start, contact HOLO for assistance.

## 10 Release Pressure:

After splicing cycle is complete, depress the red pressure relief valve button until the pressure is fully relieved.



## WARNING

Keep fingers clear of any potential pinch points, especially where beams have temporarily deflected during the splicing cycle, as they will return to their normal state when pressure is relieved.

## 11 Disconnect main power cable:

### DANGER

- It is critical to remove the power cord from the wall receptacle first.
  - Next, unlatch the cable connector from the machine base power inlet and gently disconnect.
- Following this sequence is critical for operator and bystander safety. Removing plug from the wall receptacle first eliminates any current from flowing through the cable. If this procedure is not performed first and the cable connector is removed initially, the power cable remains energized and could cause serious and fatal shock if exposed to water or other fluids.

## 12 Disconnect umbilical power cord from top beam:

- Unlatch cable connector.
- Gently disconnect.

## 13 Remove Top Beam:

- Loosen all four press connector bolts.
- Lift top beam off and place beam on side; do not place beam with platens facing downward in contact with a surface.

### CAUTION

Platen surfaces may be hot.

- Remove top silicone pad and inspect splice. Elements of a properly installed endless splice include:
  - Limited but consistent flow of PVC/Urethane material through the splice.
  - Proper bonding, especially at the tips of the fingers. 'Pin Holes' should not be present at finger tips.
  - Bending of the splice joint should not create any separation at the finger edges.
  - No scorching of the belt cover or bottom ply should be evident.

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### **14** Packing Press in Flight Case:

- a. Reassemble top beam onto press, tighten all four press connector bolts, and install clamp bars on press.
- b. Carefully place press in flight case. Note: Press must be placed in case with power receptacles facing the storage area. This will protect receptacles from getting damaged during transportation.



- c. Place power cords in storage compartment.
- d. Close case and engage the locking latches.

## SAFETY CONSIDERATIONS

This application procedure is not intended to supersede any company construction or safety standards. This procedure is offered only to illustrate safe application for the individual. FAILURE TO FOLLOW THESE PROCEDURES MAY RESULT IN PERSONAL INJURY OR DEATH.

Do not modify this product under any circumstances.

This product is intended for use by trained technicians only. This product should not be used by anyone who is not familiar with, and not trained to use it.

When working in the area of energized lines, extra care should be taken to prevent accidental electrical contact.

For proper performance and personal safety, be sure to select the proper size PREFORMED product before application.

PREFORMED products are precision devices. To insure proper performance, they should be stored in cartons under cover and handled carefully.



# HOLO BELTS PRESS MACHINE



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